

Date: Tuesday, 23/09/2008 10:22:16 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 42226	Part Number	: D323811
Estimate Number	: 12562	Drawing Number	: D3238 REV.C
P.O. Number	:	Project Number	: N/A
This Issue	: 23/09/2008 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: // Type : SMALL /MED FAB	Due Date	: 20/10/2008
Previous Run	: 33512	Qty:	132 Um: Each
Written By	:		
Checked & Approved By	: <u>JUL 08.9.23</u>		
Comment	: Est Rev:A New Issue 06-10-20 EC		
	: Est Rev:B Now on Waterjet 07-01-26 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S020	5052-H32 .020 Sheet
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Comment: Qty.: 0 sf(s)/Unit Total : 2 sf(s)  
 5052H32 aluminum sheet 0.020" thick  
 batch: 4894 IB 8-10-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3238  
 Dwg Rev: E  
 Prog Rev: E

IB 8-10-7

2-Deburr if necessary

08/10/07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/10/07

counted

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

08-10-08

X141

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:16 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 42226

Part Number: D323811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(14X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-h 08/10/08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

08/10/08 (14)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.10.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





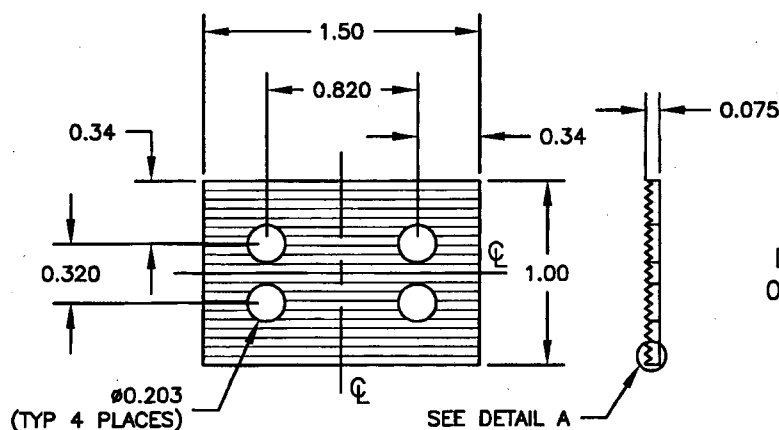
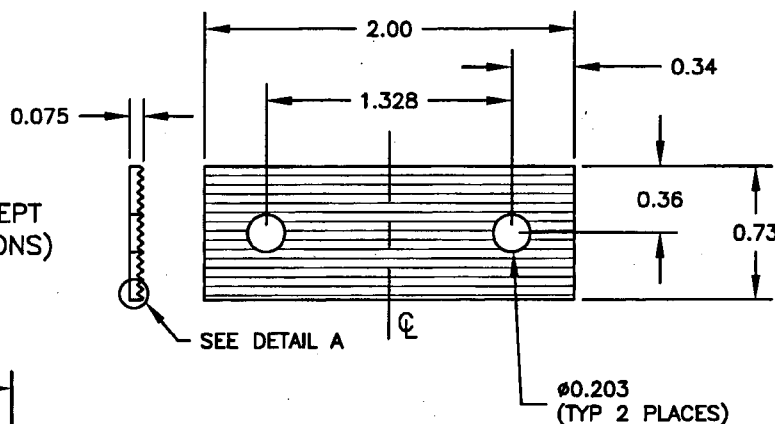
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

**D3238-1 PLATE (SHOWN)**

D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-3 PLATE (SHOWN)**

D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

**NOTES:**

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
OR

ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
AMS 4016 (REF DART SPEC M5052H32S.020)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) SEE SHEET 3 FOR DETAIL A

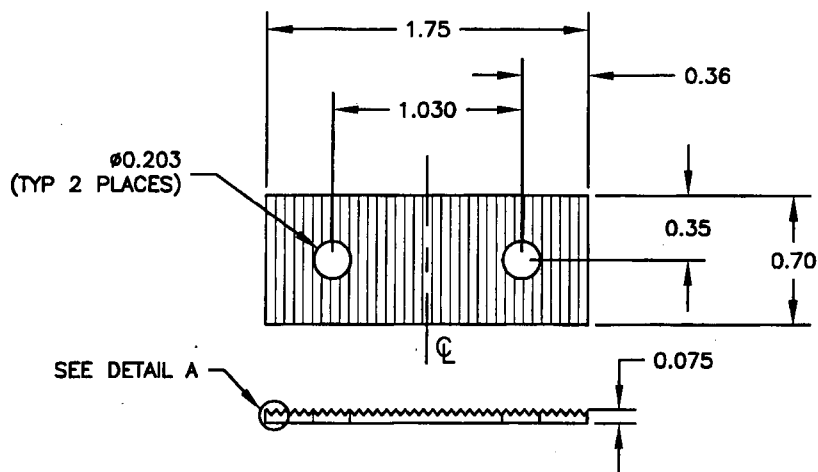
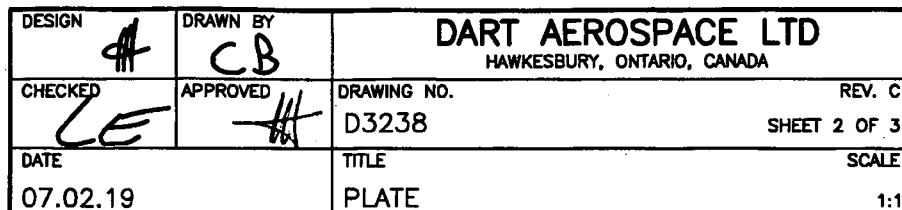
7) PARTS ARE SYMMETRIC ABOUT  $\phi$

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WITHOUT NOTICE  
WORK ORDER

NO. 42206

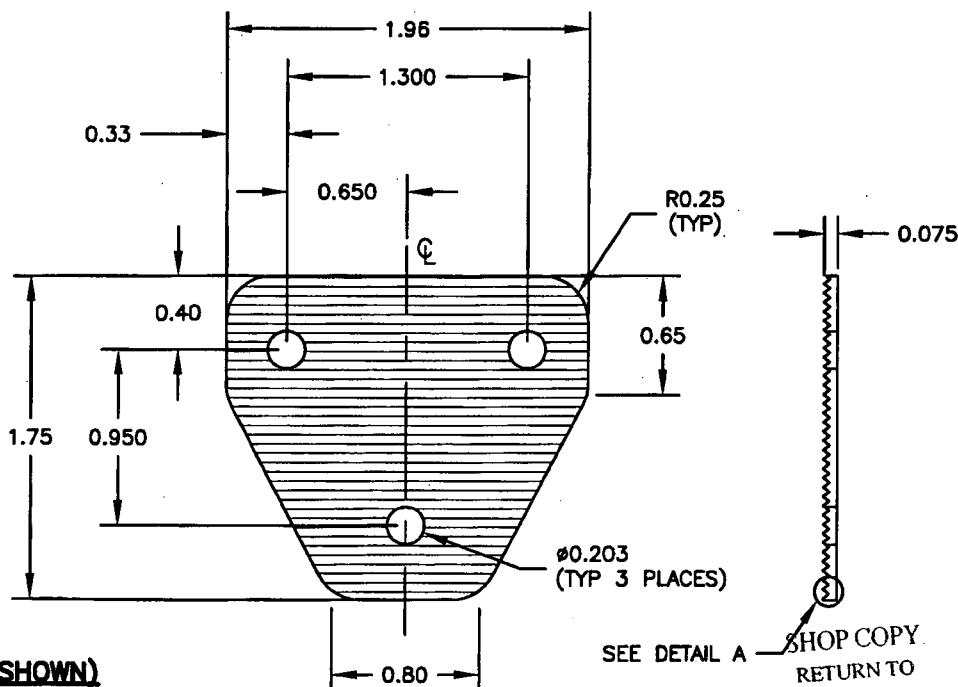
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07.02.20

**D3238-5 PLATE (SHOWN)**  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-21 PLATE (SHOWN)**  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

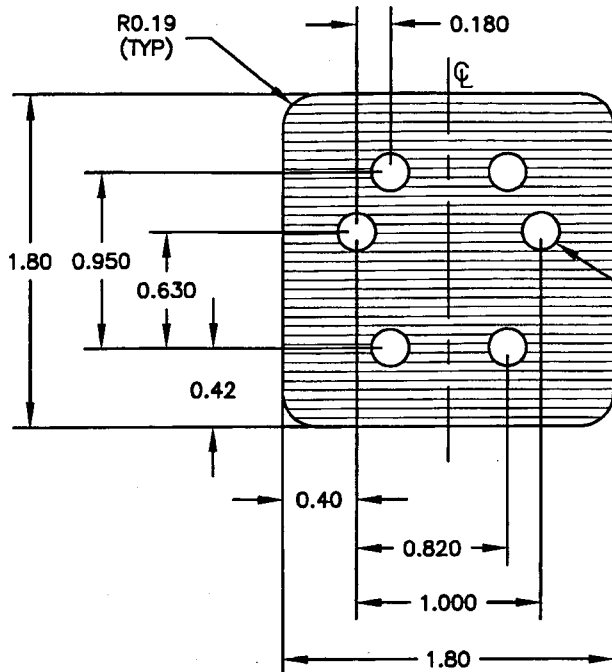
SEE DETAIL A — SHOP COPY  
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WORK ORDER  
NO. 42226

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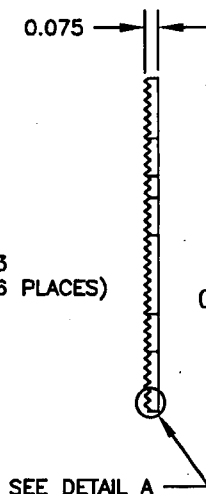
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



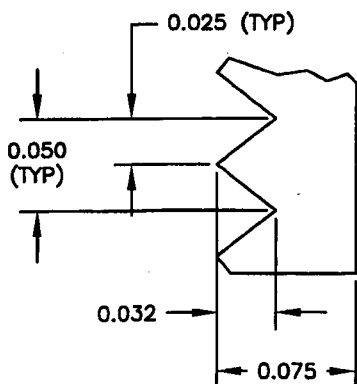
0.203  
(TYP 6 PLACES)



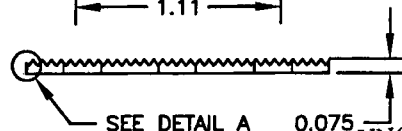
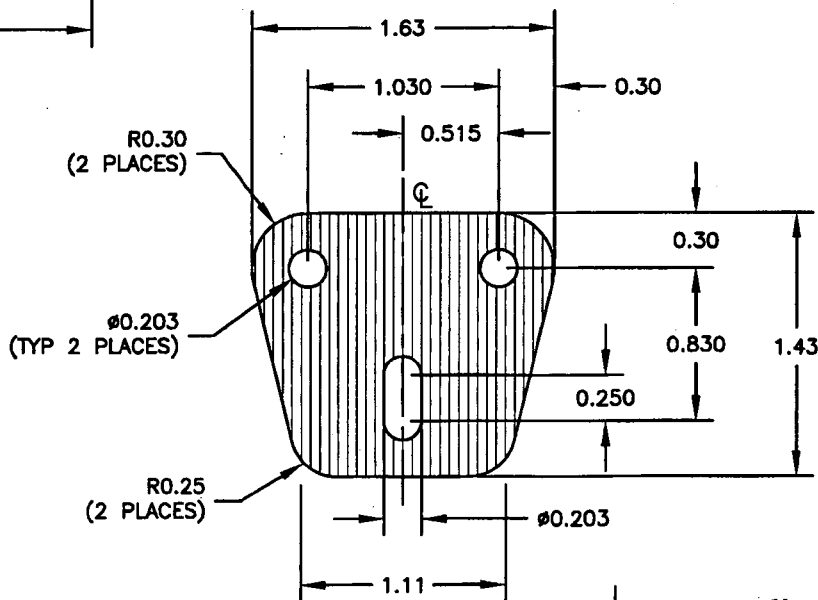
RELEASED

07.02.20

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



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42224

**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

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